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D3414-041
Job Sheet 200644



Part No: D3414-041

Job Qty: 12 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Welded Assy-1	12 pcs		10/14/19	0.00	2.40	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		ML
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
150	QC 9	12 pcs		10/14/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		AL
							QC 9 - 9		
160	QC 5	12 DCS		10/14/19	0.00	12.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S222489



Job No: D3414-041

Job No: 200644

Serial No/Batch: S222489

Revision:

Inspector:

Date:

Instructions/Various STC's

Date: 10/15/19

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						QC 5 - 9	
						QC 5 - 50	BZ
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Powdercoat - 2 White GI(S)- B4B	12 pcs	10/14/19	0.00	0.25		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 19-10-16
						Powdercoat - 4 - B4B	
180 QC 3	12 pcs	10/14/19	0.00	12.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	DAS
						QC 3 - 61	61
						QC 3 - 81	9-89
190 Packaging 3-1 - Stock - B4B	12 pcs	10/14/19	0.00	12.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 -	

				B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	Pc STS31
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	12 pcs	10/14/19	0.00 12.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	

OCT 17 2019

Part Op 140 - (Weld per dwg A/R S.S. rod Batch: M138974) 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S.
 Descriptions: welding rod Batch: M138974
 150 - (QC9- Inspect visual per QSI004- Fusion Welds)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (White Gloss(Ref 4.3.5.2) per QSI005 4.3-Steel) START TIME: 11:25 OVEN TEMPERATURE: 1100°
 FINISH TIME: 11:35 M198454
 180 - (QC3- Inspect Part Finish)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3414-3	Lug	12 pcs (1 ea)	140-Large Fab - Welded Assy-1	5170149
D3414-1	Lug Bracket	12 pcs (1 ea)	140-Large Fab - Welded Assy-1	5217496

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-1	D3414-1	12	0	0
	D3414-3	12	27	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches	+ 0.006 - 0.001	0.319 0.312	
2	Lug Bracket	1.190inches	± 0.030	1.220 1.160	
3	Lug Bracket	1.000inches	± 0.030	1.030 0.970	
4	Lug Bracket	3.380inches	± 0.030	3.410 3.350	
5	Lug Bracket	5.350inches	± 0.010	5.360 5.340	
6	Lug Bracket	6.230inches	± 0.030	6.260 6.200	
7	Lug Bracket	2.500inches	± 0.010	2.510 2.490	
8	Lug Bracket	0.370inches	± 0.030	0.400 0.340	
9	Lug Bracket	0.100inches	± 0.010	0.110 0.090	

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